

Work Order ID 61733

Tuesday, August 31, 2010 3:13:54 PM



Page 1

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning DetailL

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *BP*

Date: *10-8-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D206-667-143 | Rev C | | | | | | | | |

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio
FA087□2-Turn first side as per Folio FA087□3-File down transition lines
smooth.

(X) *Q* *MB 10-09-02*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

(X) *Q* *MB 10-09-02*

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA087□2-File down transition lines smooth.
□
3-Remove sand and plugs

(X) *Q* *MB 10-09-02*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Page 2

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Start Date: 8/31/2010 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|----------|--------------|---------------|---------------|------------------|--------------------------------|
| 130 QC Quality Control | QC1- Inspect dimensions to dimension sheet Memo | 0.00 0.00 | | | | (IX) | 2 | MB 10-09-02 | |
| 140 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | Sidorlos | | (to) | | | P10 -> Back of Picklist! |
| 150 HandFXtube Hand Finishing Crosstubes | Crosstubes Chemical Conversion Memo | 0.00 0.00 | | | | DP | | 10-9-8 | |

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Work Order ID 61733

Tuesday, August 31, 2010 3:13:54 PM



Page 3

Item ID: D206-667-103TRN

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Setup Start



Revision ID:

Item Name: Crosstube Turning DetailL

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

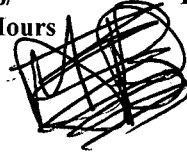
Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack ☐ Location: LG

SAD 10-09-08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/09

10-9-08

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 3:13:58 PM

Page 1/1

Work Order ID: 61733

Parent Item: D206-667-103TRN

Parent Item Name: Crosstube Turning DetailL


Start Date: 8/31/2010

Required Date: 9/13/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6002-115  Crosstube Material | | Manufactured | No | | | 110 | Each | 52.0000 | 1 | 1 | | | |



MB 10-09-01

Location

LG

34684
34776

Loc Qty

52

1

51

Loc Code

~~1x~~ 1K

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D206-667-103TR PAR #: _____ Fault Category: X-tube NCR: Yes No DQA: 2 Date: 10/09/13
 Resolution: Accepted Disposition: Use as is QA: N/C Closed: 1 Date: 10/09/13

| NCR: <u>61733</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|---|---------------------------------|-----------------------|---------------------------|--|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/09/07 | 100 | Cuff O.D. below tolerance by 0.004 RL offset wrong on cuff only. 1st side. #Process | <u>CP</u> 10/09/07 <u>QSI 042</u> | <u>Acceptable</u> | <u>MB</u> 10-09-07 | <u>S</u> 10/09/08 | <u>P</u> 10/09/07 <u>QSI 042</u> | <u>S</u> 10/09/08 |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | |
|--|----------------------------------|
| DART AEROSPACE LTD | Work Order: 61733 |
| Description: Crosstube Assembly (206L High Fwd) | Part Number: D206-667-143 |
| Inspection Dwg: D206-667-143 Rev: <i>BC</i> | Page 1 of 1 |

20.09.02
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|------------------------------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.236 | | ✓ | CALIPER | Acceptable <i>P.D. 09.07</i> |
| | 1.982 | +0.005/-0.000 | 1.984 | ✓ | | " | |
| | 2.019 | +0.005/-0.000 | 2.021 | ✓ | | " | |
| | 2.058 | +0.005/-0.000 | 2.062 | ✓ | | " | |
| | 2.097 | +0.005/-0.000 | 2.101 | ✓ | | " | |
| | 2.136 | +0.005/-0.000 | 2.141 | ✓ | | " | |
| | 2.176 | +0.005/-0.000 | 2.180 | ✓ | | " | |
| | 2.201 | +0.005/-0.000 | 2.206 | ✓ | | " | |
| | | | | | | " | |
| | 0.125 | +/-0.010 | .125 | ✓ | | " | |
| | 0.400 x 30° | +/-0.010 | 0.400x30° | ✓ | | " | |
| | R0.063 | +/-0.010 | R0.063 | ✓ | | " | |
| | R0.500 | +/-0.010 | R0.500 | ✓ | | " | |
| | 4.438 | +/-0.030 | 4.439 | ✓ | | " | |
| SIDE B | 104.98 | +/-0.020 | 104.98 | ✓ | | Measuring Tape | |
| | 2.240 | +0.005/-0.000 | 2.238 | | ✓ | CALIPER | Acceptable <i>P.D. 09.07</i> |
| | 1.982 | +0.005/-0.000 | 1.982 | ✓ | | " | |
| | 2.019 | +0.005/-0.000 | 2.019 | ✓ | | " | |
| | 2.058 | +0.005/-0.000 | 2.060 | ✓ | | " | |
| | 2.097 | +0.005/-0.000 | 2.099 | ✓ | | " | |
| | 2.136 | +0.005/-0.000 | 2.140 | ✓ | | " | |
| | 2.176 | +0.005/-0.000 | 2.176 | ✓ | | " | |
| | 2.201 | +0.005/-0.000 | 2.202 | ✓ | | " | |
| | | | | | | " | |
| | 0.125 | +/-0.010 | 0.125 | ✓ | | " | |
| | 0.400 x 30° | +/-0.010 | 0.400x30° | ✓ | | " | |
| | R0.063 | +/-0.010 | R0.063 | ✓ | | " | |
| | R0.500 | +/-0.010 | R0.500 | ✓ | | " | |
| | 4.438 | +/-0.030 | 4.439 | ✓ | | " | |

| | | | |
|-------------------------------|-----------------------------|----------------------------|-----|
| Measured by: <i>MB</i> | Audited by: <i>S</i> | Prototype Approval: | N/A |
| Date: 10-09-02 | Date: 10/9/02 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|--------------------|
| A | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| Item | Qty -143 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 41733
Bf10-8-31

RELEASED
2011/11/14

| | | | |
|------------|--|--|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2858-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. | REV. C |
| CHECKED | RF | D206-667-143 | SHEET 1 OF 4 |
| MFG. APPR. | RF | TITLE | SCALE |
| APPROVED | RF | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
| DE APPR. | RF | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.11.06 | | |

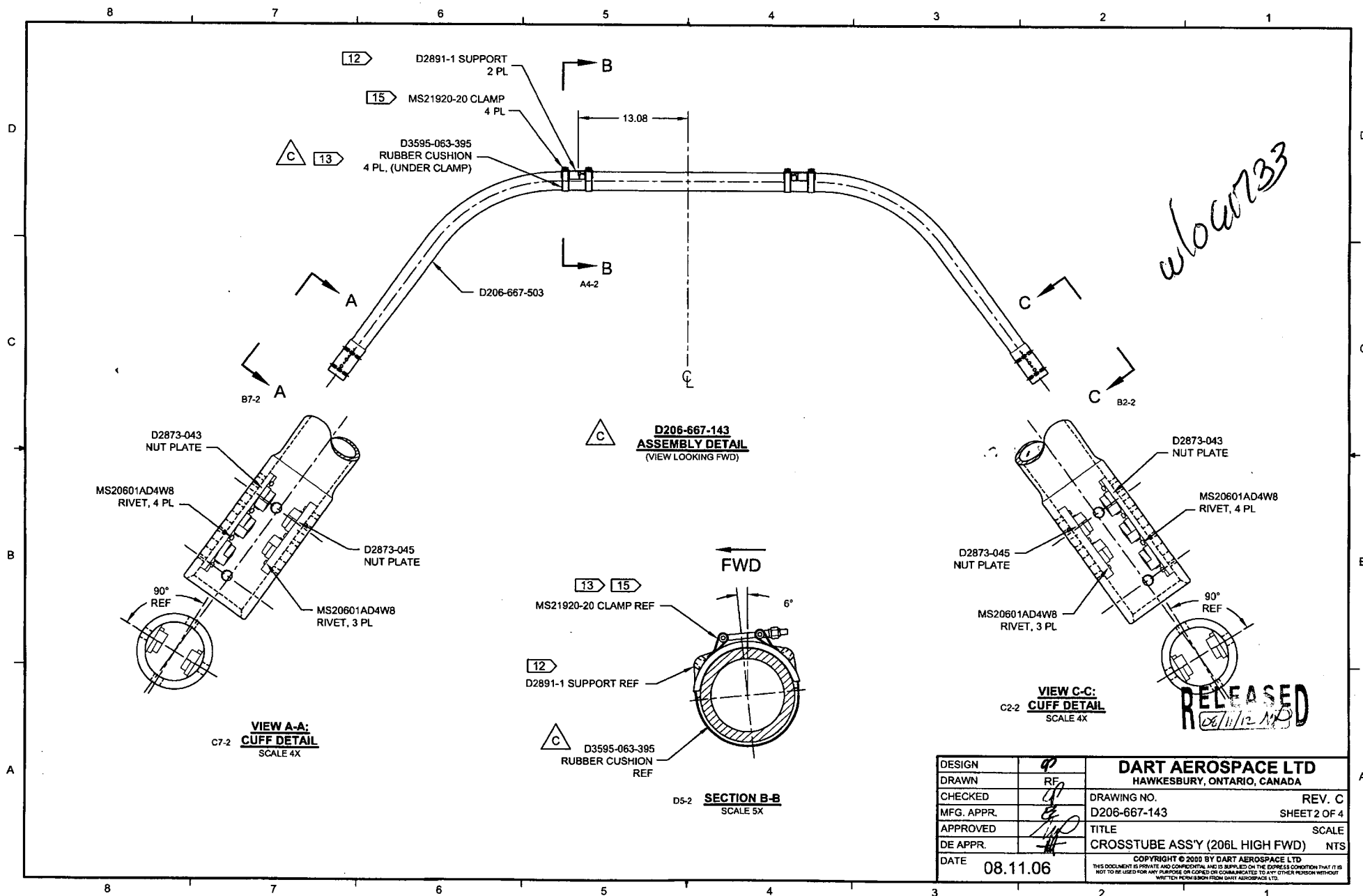
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NOTE: Date & initial all entries



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| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LP | DRAWING NO. | REV. C |
| MFG. APPR. | EP | D206-667-143 | SHEET 2 OF 4 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
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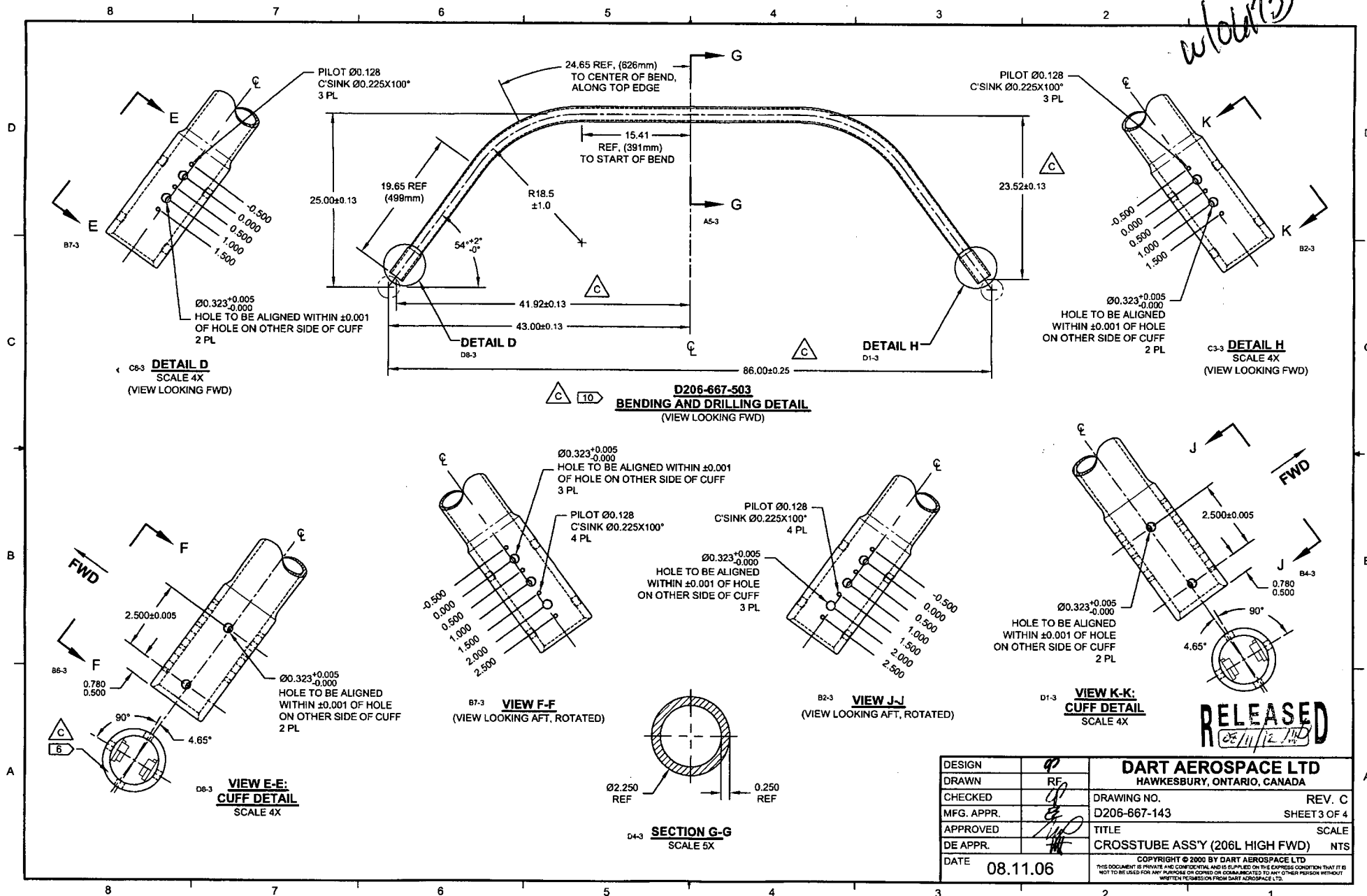
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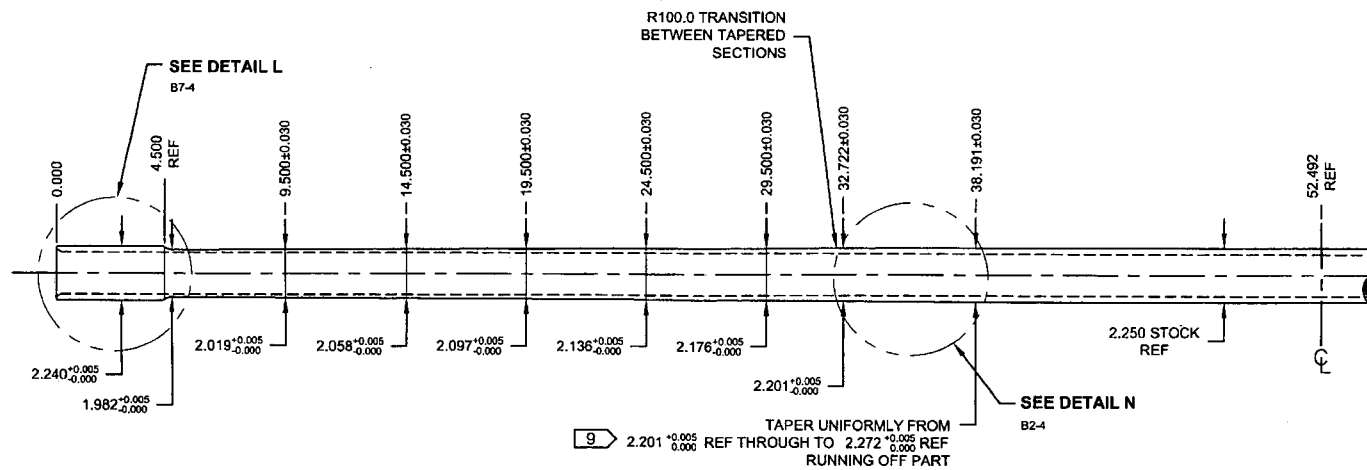
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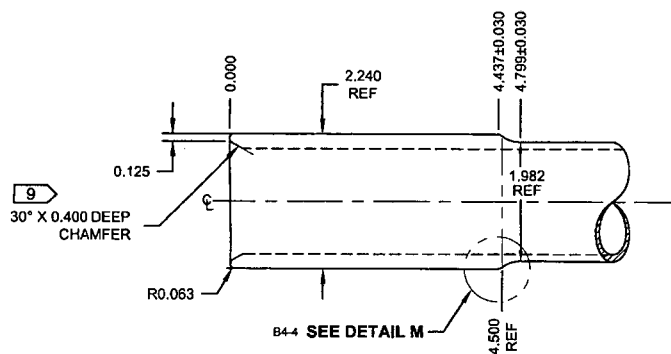
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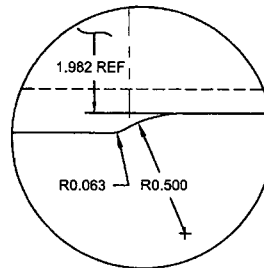
NOTE: Date & initial all entries



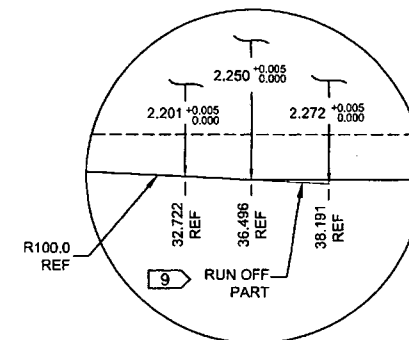
C TURNING DETAIL



DETAIL L:
D7-4 CROSTUBE CUFF
NOT TO SCALE



DETAIL M:
A5-4 CUFF TRANSITION
NOT TO SCALE



DETAIL N:
C4-4 TAPER RUN-OFF
NOT TO SCALE

RELEASED

| | | | |
|--|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | REV. C |
| MFG. APPR. | JP | D206-667-143 | SHEET 4 OF 4 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | CROSTUBE ASS'Y (206L HIGH FWD) | NTS |
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